

February 9, 2011 3:47:14 PM



Accept

**Setup Start**

Stop



11-11-11

Cust Item ID:[illegible]

Customer:

Reference:

Run Start



Date:

Stop



Date:

Draw Nbr	Revision Nbr
D4278	C

100	Weld per dwg	A/R	S.S. rod	Batch: <u>111585</u>	0.00
-----	--------------	-----	----------	----------------------	------



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs and weld as per dwg DT

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
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QC

Memo

0.00

Quality Control

120	QC5- Inspect part completeness to step on W/O	0.00
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QC

Memo

0.00

Quality Control

Work Order ID 66309

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Page 2

Item ID:	D4278-045	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly, Fwd Cham					
Start Date:	2/10/11	Start Qty:	2.00		Cust Item ID:	
Required Date:	2/17/11	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Identify as per dwg & Stock Location: <u>B/C</u>	0.00							
Packaging	Memo	0.00							
Packaging	***STOCK IN BASKET CELL***								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Pl 11-02-21

11/02/22

Pl 11-02-22

Picklist Print

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Page 1

Work Order ID: 66309

Parent Item: D4278-045

Parent Item Name: Rib Assembly, Fwd Cham



Start Date: 2/10/11



Required Date: 2/17/11


Start Qty: 2.00

Required Qty: 2.00

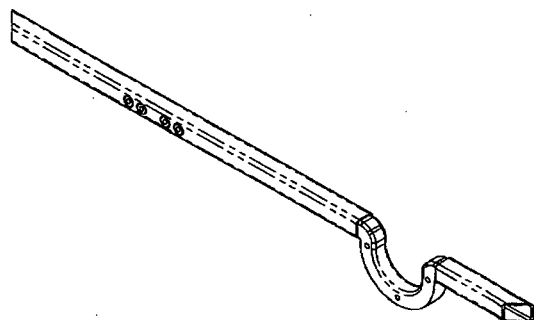
Comments: IPP Rev:A 10.11.12 new issue DD verf:EC
11.01.20 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4277-11  Rib		Manufactured	No			100	Each	0.0000	1 2				
D4277-7  Rib		Manufactured	No			100	Each	0.0000	1 2				

 B66424 → (2) Pl 11.02.17

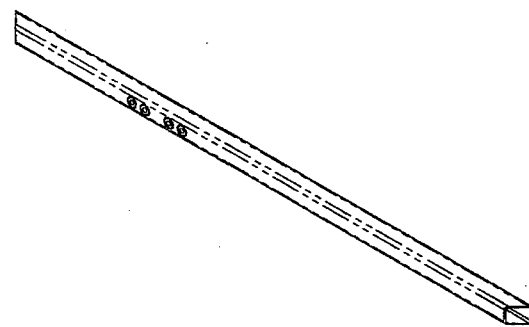
 B66425 → (2) Pl 11.02.17



D4278-041 UPPER RIB ASSY-HOOP



D4278-045 RIB ASSY, FWD CHAM



D4278-047 UPPER RIB ASSY-STRAIGHT

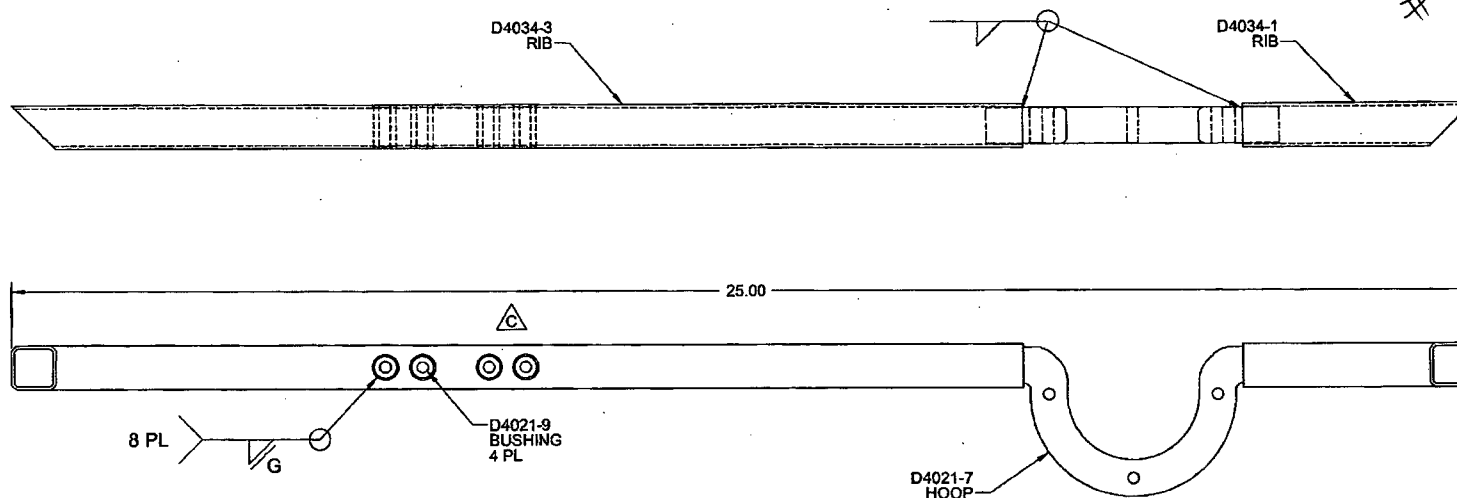


66309

RELEASED
R 2011-01-18
M

C	ADDITIONAL HOLES ADDED IN D4278-041/-047	SC	10.12.23
B	RMV -043 (OBSOLETE)	CP	10.11.30
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	JPH	DRAWING NO.	REV. C
MFG. APPR.	JPH	D4278	SHEET 1 OF 4
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	RIB ASSEMBLY	NTS
DATE	10.12.23	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-041	UPPER RIB ASSY-HOOP
1	1	D4021-7	HOOP
2	4	D4021-9	BUSHING
3	1	D4034-1	RIB
4	1	D4034-3	RIB



D4278-041 UPPER RIB ASSY-HOOP

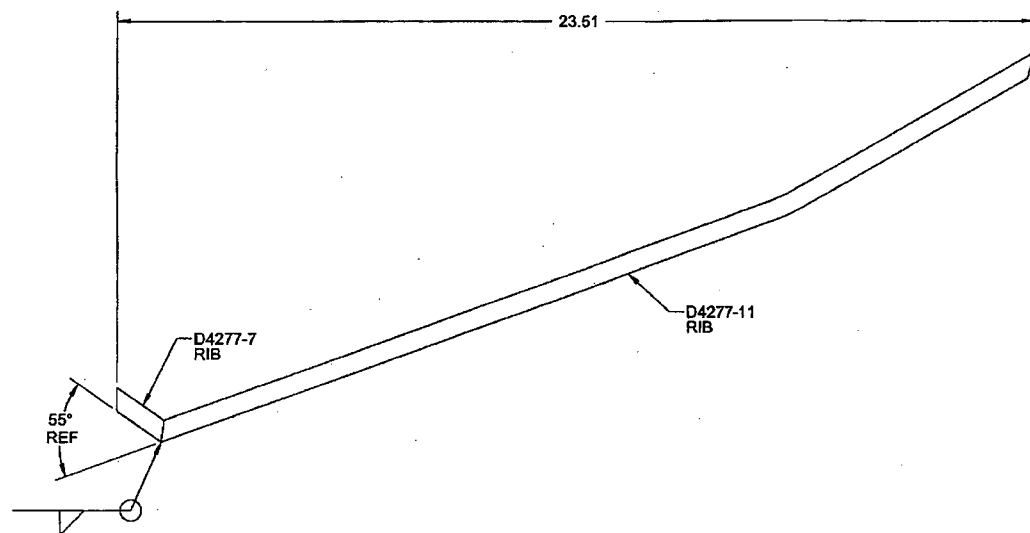
RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.61 lbs
- 8) WELD PER DART QSI 004

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
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ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-045	RIB ASSY, FWD CHAM
1	1	D4277-7	MID CORNER RIB, NOTCH
2	1	D4277-11	MID DIAG RIB



D4278-045 RIB ASSY, FWD CHAM

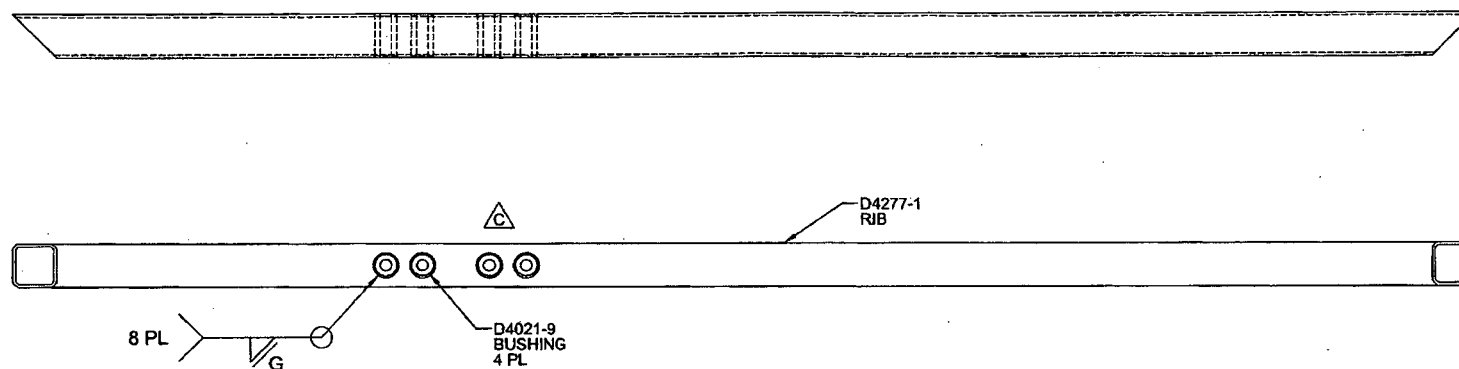
#66309

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.57 lbs
- 8) WELD PER DART QSI 004.

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	SC	DRAWING NO. D4278	REV. C SHEET 3 OF 4
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DE APPR.			
DATE	10.12.23		

ITEM	QTY	PART NUMBER	DESCRIPTION
		D4278-047	UPPER RIB ASSY-STRAIGHT
1	4	D4021-9	BUSHING
2	1	D4277-1	RIB



D4278-047 UPPER RIB ASSY-STRAIGHT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.95 lbs
- 8) WELD PER DART QSI 004.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4278	SHEET 4 OF 4
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R 2011-01-10
MD

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